



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

9.574

D4776-1

Job Sheet 183441



Part No: D4776-1

Job Qty: 10 ea

Part Name: Basket Strut Clevis



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/18/18

Job Tracking No:

Due Date: 10/5/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV D SHEET 1 IPP REV:A 13.02.28 NEW ISSUE DD VERF:JFS IPP REV:B 13.09.26 AS PER REV.B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		10/5/18	0.00	0.00	Start Up Machining-3		
100	Doosan	10 pcs		10/5/18	0.54	5.32	Doosan		
105	QC	10 pcs		10/5/18	0.00	0.00	QC2 Machining-3		
111	QC	10 pcs		10/5/18	0.00	0.00	QC8 Machining-3		
112	HandFinish	10 pcs		10/5/18	0.00	0.29	HandFinish1		
113	QC	10 pcs		10/5/18	0.00	0.00	QC7-4		
115	Powdercoat	10 pcs		10/5/18	0.00	0.12	Powdercoat1		
116	QC	10 pcs		10/5/18	0.00	0.00	QC3		
130	Packaging	10 pcs		10/5/18	0.00	0.00	Packaging3-2		
140	QC21-SA	10 Ea		10/5/18	0.00	0.00	QC21		

Part Op 100 - 1- Turn as per Folio FB167 Dwg D4776 Rev: 2

Descriptions: 115 - MASK .403 ROUND SECTION AS PER DWG

M83983 START: 7:30 DU: T1300 FINISH 2 8:00

Handwritten notes and signatures:
18/10/11
18/10/11
18-10-11
18-10-12
DAS 38
6 9-80
9-80 OCT 15 2018
DAS 21
9-80 OCT 15 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R1.500	6061-T6 Round Bar 1.50	2.9000 ft (.29 ea)	90-Start up Operation	Scrap 13

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R1.500	3	22	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Basket Strut Clevis	0.880Inches ± 0.030	0.910 0.850		
2	Basket Strut Clevis	0.438Inches ± 0.010	0.448 0.428		
3	Basket Strut Clevis	0.380Inches ± 0.030	0.410 0.350		
4	Basket Strut Clevis	0.625Inches ± 0.010	0.635 0.615		

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

5	Basket Strut Clevis	1.750Inches $\pm$ 0.030	1.780 1.720	
6	Basket Strut Clevis	3.500Inches $\pm$ 0.030	3.530 3.470	
7	Basket Strut Clevis	45.000Degrees $\pm$ 0.500	45.500 44.500	Angle
8	Basket Strut Clevis	0.030Inches $\pm$ 0.030	0.060 0.000	
9	Basket Strut Clevis	0.060Inches $\pm$ 0.030	0.090 0.030	Radius
10	Basket Strut Clevis	0.196Inches $\pm$ 0.006 - 0.001	0.202 0.195	Diameter
11	Basket Strut Clevis	0.261Inches $\pm$ 0.006 - 0.001	0.267 0.260	Diameter
12	Basket Strut Clevis	0.410Inches $\pm$ 0.030	0.440 0.380	Radius
13	Basket Strut Clevis	1.130Inches $\pm$ 0.030	1.160 1.100	
14	Basket Strut Clevis	0.188Inches $\pm$ 0.010	0.198 0.178	
15	Basket Strut Clevis	0.190Inches $\pm$ 0.030	0.220 0.160	
16	Basket Strut Clevis	0.500Inches $\pm$ 0.030	0.530 0.470	
17	Basket Strut Clevis	0.750Inches $\pm$ 0.010	0.760 0.740	
18	Basket Strut Clevis	0.403Inches $\pm$ 0.000 - 0.005	0.403 0.398	Diameter
19	Basket Strut Clevis	0.130Inches $\pm$ 0.030	0.160 0.100	Radius
20	Basket Strut Clevis	0.750Inches $\pm$ 0.010 - 0.000	0.760 0.750	
21	Basket Strut Clevis	0.160Inches $\pm$ 0.030	0.190 0.130	
22	Basket Strut Clevis	45.000Degrees $\pm$ 0.500	45.500 44.500	Angle

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Work ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																					
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